

# Work Order ID 80990

March-06-12 9:17:38 AM

\*80990\*

Page 1

Item ID: D2661-2

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop

\*NS2\*

Start Date: 06/03/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/06 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2661	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*100*</b>									
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: <u>AA</u> DWG REV: <u>E</u>								
			12/03/06	FK		22			
				12/07/07					
110	CONVENTIONAL MILLING MACHINE	0.00							
<b>*110*</b>									
Mill Conv	<b>Memo</b>	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
			FK	12/07/07		22			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80990

March-06-12 9:17:38 AM

**\*80990\***

Page 2

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, RH Fwd Aft Out 206  
Start Date: 06/03/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 20/03/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	F.K / 12/07/06 12/07/06			22	28		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	OK 12/07/08			22	10		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				22	76	12-79	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80990

March-06-12 9:17:38 AM

**\*80990\***

Page 3

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft Out 206  
 Start Date: 06/03/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 20/03/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Memo START TIME: <u>10:30</u> FINISH TIME: <u>3200</u>	0.00				22X	φ		Mf 12/07/09
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00				22	φ	41279	
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>434</u>	0.00							
	Memo	0.00				22		12-7-10 SP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80990**

March-06-12 9:17:38 AM

**\*80990\***

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Item ID: D2661-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop **\*NS2\***

Start Date: 06/03/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

OK 12/7/11

MF  
12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-06-12 9:17:41 AM

Page 1

Work Order ID: 80990

\*80990\*

Parent Item: D2661-2

\*D2661-2\*

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	47.0000	1	20			

\*D6101-003\*

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Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	28	
73775	2	
73780	7	
78159	2	
78599	10	
MAT041	25	
79587	25	
MAT042	-7	
MAT044	1	
73769	1	

81924

85434

10

12

F.K 12/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80996
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		Page 1 of 2	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.614	3.614	3.615	3.615
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.500	2.500	2.499	2.502	2.502
E	1.674	1.684		1.679	1.683	1.682	1.683	1.681
F	1.357	1.367		1.362	1.363	1.3625	1.362	1.363
G	0.100	0.140		.124	.118	.117	.117	.113
H	0.210	0.230		.227	.225	.220	.221	.221
I	0.615	0.685		.680	.667	.680	.680	.680
J	2.470	2.510		2.492	2.492	2.493	2.492	2.492
K	1.313	1.343		1.326	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.130	1.130	1.130	1.127
O	0.100	0.180		.135	.140	.140	.140	.140
P	0.100	0.140		.115	.126	.122	.116	.119
Q	0.240	0.260		.250	.252	.251	.252	.250
R	0.677	0.697		.687	.691	.691	.690	.691
S	0.100	0.140		.122	.128	.128	.125	.127
T	1.565	1.585		1.577	1.570	1.570	1.570	1.567
U	0.540	0.560		.550	.547	.546	.547	.545
V	0.912	0.932		.923	.928	.929	.927	.928
W	0.787	0.807		.797	.796	.798	.795	.794
X	5.990	6.010		6.000	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	4.999	4.997	4.999	4.999
Z	0.490	0.510		.500	.502	.504	.5005	.504
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.001	1.001	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510	.500	<del>3.745</del>	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.749	3.749	3.749	3.749
AF	0.235	0.240		.237	<del>236</del>	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.111	.111	.111	.111
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80990
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

<b>Measured by:</b> <i>J. F. K.</i>	<b>Date:</b> 12/07/05
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<b>Audited by:</b> <i>CMZ</i>	<b>Date:</b> 12/07/08
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<b>Prototype Approval:</b>	<b>Date:</b>
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Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80996
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	3.611	3.621	<del>3.614</del>	3.614	3.615	3.614	3.615	3.613
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.501	2.499	2.501	2.5015	2.502
E	1.674	1.684		1.681	1.680	1.679	1.6815	1.681
F	1.357	1.367		1.361	1.363	1.3615	1.363	1.362
G	0.100	0.140		.111	.109	.107	.109	.115
H	0.210	0.230		.220	.217	.217	.218	.219
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.492	2.492	2.492	2.492	2.492
K	1.313	1.343		1.323	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1317	1.129	1.128	1.1316	1.1327
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.115	.122	.118	.115	.116
Q	0.240	0.260		.251	.253	.254	.252	.250
R	0.677	0.697		.691	.691	.690	.691	.691
S	0.100	0.140		.125	.124	.124	.123	.123
T	1.565	1.585		1.5722	1.5695	1.568	1.5714	1.5735
U	0.540	0.560		.545	.545	.545	.547	.546
V	0.912	0.932		.921	.928	.929	.927	.928
W	0.787	0.807		.795	.796	.795	.797	.794
X	5.990	6.010		6.001	6.000	6.000	6.000	6.000
Y	4.995	5.005		4.999	5.000	5.000	5.000	5.000
Z	0.490	0.510		.503	.502	.5025	.5005	.5005
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.001	1.001	1.001	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80990
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

**Measured by:** *JS / E.E.* **Date:** 12/07/06

**Audited by:** *conk* **Date:** 12/07/08

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80996
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661	<b>Rev:</b> E	<b>DSK:</b>	<b>Rev:</b>
			Page 1 of 2

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11 X	12 X	13 X	14 X	15 X
A	3.611	3.621		3.615	3.614	3.6135	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.502	2.500	2.499	2.501	2.500
E	1.674	1.684		1.681	1.679	1.681	1.679	1.679
F	1.357	1.367		1.363	1.362	1.363	1.362	1.362
G	0.100	0.140		.115	.124	.119	.120	.120
H	0.210	0.230		.218	.220	.215	.218	.218
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.144	1.141	1.141	1.140
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.115	.111	.112	.115	.114
Q	0.240	0.260		.248	.240	.240	.248	.241
R	0.677	0.697		.688	.690	.689	.689	.687
S	0.100	0.140		.123	.118	.118	.118	.118
T	1.565	1.585		1.5762	1.581	1.578	1.581	1.5796
U	0.540	0.560		.5485	.547	.547	.549	.550
V	0.912	0.932		.926	.925	.926	.925	.925
W	0.787	0.807		.797	.796	.798	.796	.795
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.502	.500	.503	.503
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80990
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

<b>Measured by:</b>	<i>[Signature]</i>	<b>Date:</b>	12/07/06
<b>Audited by:</b>	<i>[Signature]</i>	<b>Date:</b>	12/07/08
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80996
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		Page 1 of 2	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.121	.120	.120	.120	.122
H	0.210	0.230		.218	.218	.220	.217	.217
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.324	1.324	1.326
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.140	1.142	1.135	1.136	1.138
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.118	.115	.117	.117	.117
Q	0.240	0.260		.241	.241	.250	.250	.250
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.120	.120	.123	.124	.125
T	1.565	1.585		1.580	1.582	1.5755	1.576	1.578
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.923	.926	.926	.926
W	0.787	0.807		.796	.796	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.006	5.000	5.000	5.000
Z	0.490	0.510		.502	.502	.503	.503	.503
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80990
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2661-2
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

<b>Measured by:</b>	<i>SJ / F.R.</i>	<b>Date:</b>	12/07/07
<b>Audited by:</b>	<i>cmz</i>	<b>Date:</b>	12/07/08
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
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F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

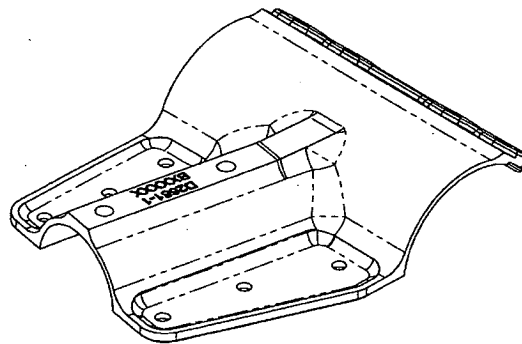
<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 80990	
<b>Description:</b> 206 Saddle, Outboard, Right side				<b>Part Number:</b> D2661-2	
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

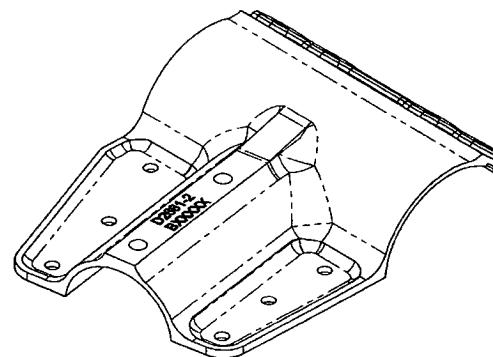
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21 X	22 X	3	4	5
A	3.611	3.621		3.616	3.616			
B	0.256	0.263		.258	.258			
C	0.315	0.322		.317	.317			
D	2.495	2.505		2.500	2.500			
E	1.674	1.684		1.679	1.679			
F	1.357	1.367		1.362	1.362			
G	0.100	0.140		.120	.121			
H	0.210	0.230		.218	.218			
I	0.615	0.685		.680	.680			
J	2.470	2.510		2.490	2.490			
K	1.313	1.343		1.324	1.324			
L	0.178	0.198		.188	.188			
M	0.470	0.530		.500	.500			
N	1.125	1.145		1.136	1.1365			
O	0.100	0.180		.135	.135			
P	0.100	0.140		.117	.116			
Q	0.240	0.260		.250	.247			
R	0.677	0.697		.687	.687			
S	0.100	0.140		.125	.125			
T	1.565	1.585		1.576	1.577			
U	0.540	0.560		.550	.550			
V	0.912	0.932		.924	.924			
W	0.787	0.807		.797	.797			
X	5.990	6.010		6.000	6.000			
Y	4.995	5.005		5.000	5.000			
Z	0.490	0.510		.500	.500			
AA	0.312	0.319		.314	.314			
AB	0.990	1.010		1.001	1.000			
AC	1.245	1.255		1.250	1.250			
AD	0.490	0.510		.502	.502			
AE	3.745	3.755		3.750	3.750			
AF	0.235	0.240		.236	.236			
AG	0.510	0.515		.512	.512			
AH	0.100	0.120		.111	.111			
Accept/Reject								

<b>Measured by:</b> F.K. <del>12/07/07</del>	<b>Date:</b> 12/07/07
<b>Audited by:</b> <del>12/07/07</del>	<b>Date:</b> 12/07/08
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

**RELEASED**  
2011-11-16

SHOP COPY  
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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 80990 MLJ

12/03/06

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	SADDLE, OUTSIDE	NTS	
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



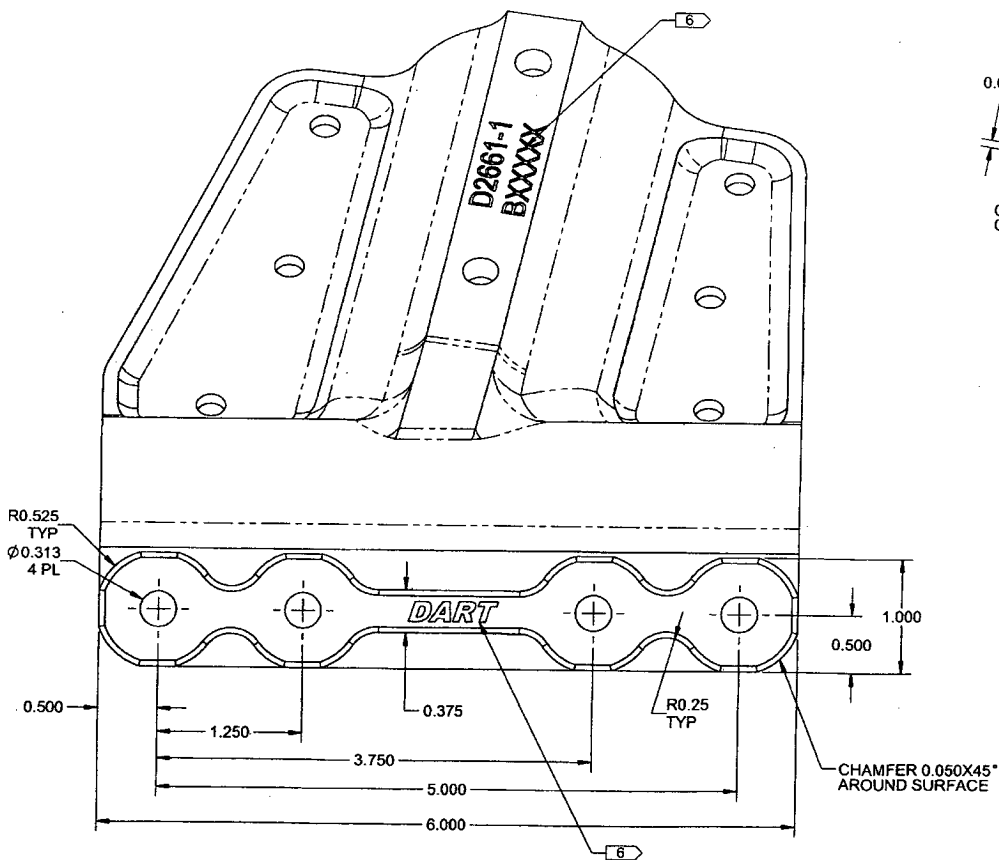
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

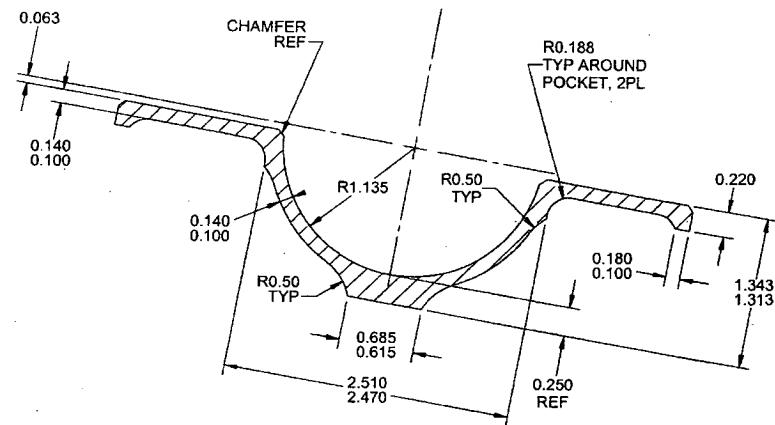
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**VIEW B-B**  
SCALE 1.5X A4-2  
VIEW ROTATED



**VIEW A-A**  
SCALE 1.5X C3-2

**RELEASED**  
2011-11-16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. <b>D2661</b>	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SCALE	
DE APPR.		SADDLE, OUTSIDE	
DATE	11.10.31	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

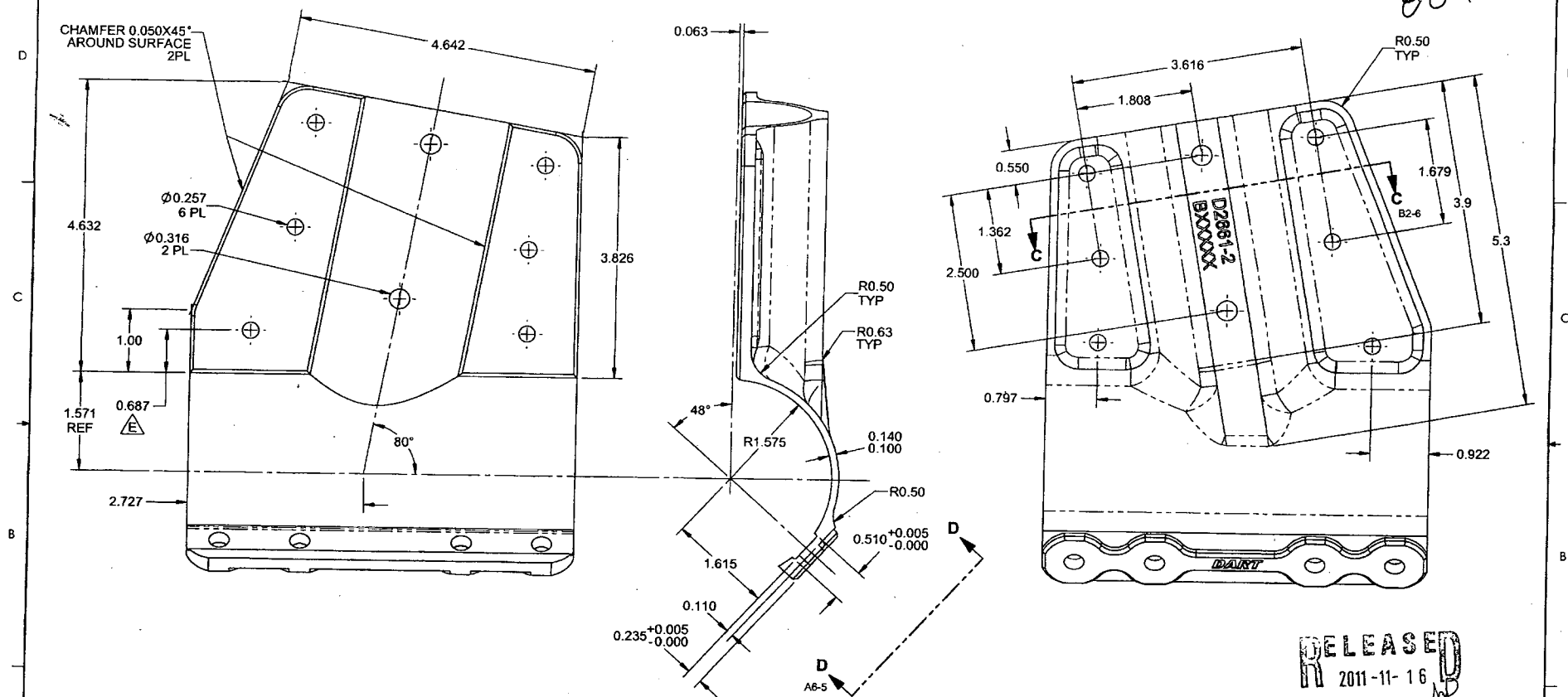
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80990



RELEASED  
2011-11-16

**D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

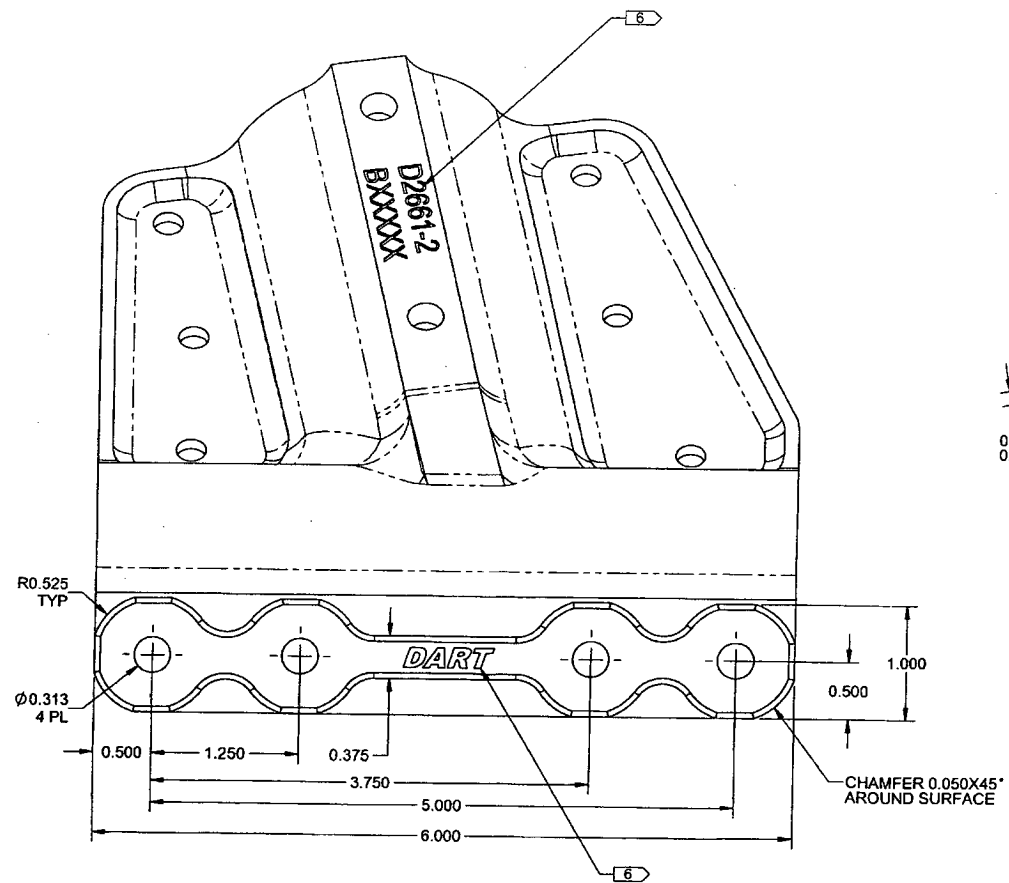
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

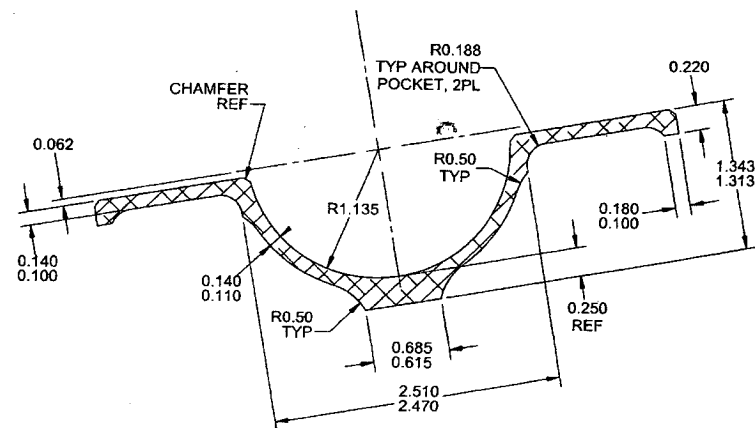
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80990



VIEW D-D 84-4  
SCALE 1.5X  
VIEW ROTATED



SECTION C-C C1-4  
SCALE 1.5X

RELEASED  
2011-11-16

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries